

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Work Order ID 160974

Friday, May 05, 2017 11:40:23 AM

160974

Page 2

Item ID: D3447-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Square Spacer
Start Date: 5/11/2017 Start Qty: 7.00 ***7*** Cust Item ID:
Required Date: 5/17/2017 Req'd Qty: 7.00 ***7*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 <i>M134092</i> Memo Mask inside wall TEMPERATURE: <i>300</i> FINISH TIME: <i>2:25</i> OVEN <i>2:55</i>	0.00 <i>0.43</i>				<i>7</i>	<i>0</i>	<i>17-06-01</i>	<i>23 08</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>7</i>			<i>DAS 38 9-89</i> <i>JUN 02 2017</i>
150 *150* Packaging Packaging	Identify as per dwg & Stock Location <i>WAP03</i> Memo	0.00 0.00				<i>7</i>			<i>DAS 6 9-89</i> <i>JUN 02 2017</i>

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Work Order ID 160974***160974***

Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

17/6/17 *[Signature]*

DAS
21
9-89

JUN 02 2017

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Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
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Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Picklist Print

Friday, May 05, 2017 11:40:22 AM

Page 1

Work Order ID: 160974

160974

Parent Item: D3447-3

D3447-3

Parent Item Name: Square Spacer

Start Date: 5/11/2017

Required Date: 5/17/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP A05.10.19New issueKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS1.000W.12 0		Purchased	No			100	f	17.7363	0.1771	1.304947			

~~*M6061T6TS1.000W.120*~~

6061T6 SQ TUBE 1.00 x 1.00 X .120w

**

MAY 23 2017

DAS
19
9-89

DAS
10
9-89

125
AA

Location

MAT051

m126686

m136101

Loc Qty

17.736265

10.447157

7.289108

Loc Code

1.5

137541

not pulled

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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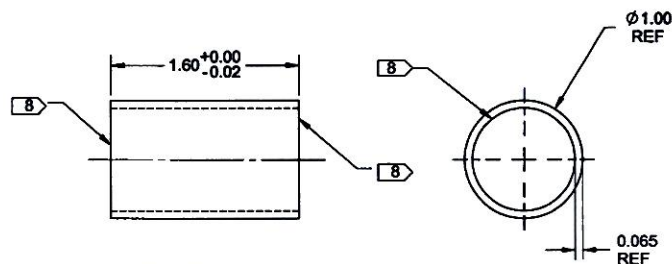
Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

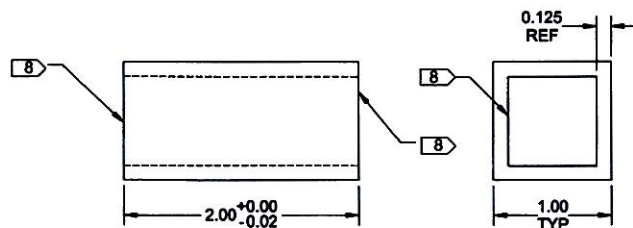
NO. 160974MLJ

1705-07



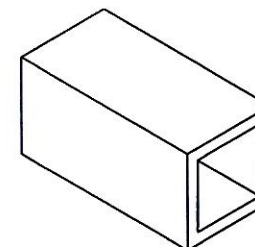
D3447-1 ROUND SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR
ASTM B221
REF. DART SPEC. M6061T6T1.000W.065



D3447-3 SQUARE SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6T1.000W.125



NOTES:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A OR PER QSI 044 6.1
- 7) WEIGHT: D3447-1 = 0.03 lbs; D3447-3 = 0.09 lbs
- 8) MASKING: INSIDE OF TUBING AND ENDS BEFORE PAINTING.

RELEASED
2016-11-28
ECW 11-678

APPROVED

C	D3447-3: M7075-T6 WAS M6061-T6 (ZN A5-4), REASON IS TO CORRECT PREVIOUS REVISIONS AND TO MATCH PREMIER ORIGINAL DRAWING.	SAD	16.11.22
B	REDRAW TO CURRENT STD; Ø0.280 WAS Ø0.250 (ZN B3-2) AND (ZN C6-3), ADD TOLERANCE (ZN B5/D5-1), UPDATED MATERIAL SPECIFICATION, REASON PAR15-437	SAD	16.08.26
A	NEW ISSUE	MB	05.07.19
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SAD		
CHECKED	MB		
MFG. APPR.	JLM		
APPROVED	WM		
DE APPR.	N/A		
DATE	16.11.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3447** REV. C
SHEET 1 OF 4
TITLE **BLADE FOLD KIT PARTS** SCALE NTS

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